

Work Order ID 125904

Friday, October 24, 2014 11:12:15 AM

125904

Page 1

Item ID: D3492-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plug

Stop

NS2

Start Date: 10/27/14 Start Qty: 400.00

400

Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-10-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3492	E

100 0.00 DAS
100 Hardinge CNC LATHE SMALL 37
Hardinge Memo 0.00 9-89 14.10.28

Hardinge CNC Lathe Small 1-Turn as per Folio FA633 & Dwg D3492
Dwg Rev: E
Folio Rev: A

110 0.00 DAS
110 QC2- Inspect parts off machine FAI/FAIB 37
QC Memo 0.00 9-89 14.10.28

Quality Control

120 0.00 JFL 20M11-06
120 QC8- Inspect parts - second check 0.00
QC Memo 0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear		General							
		Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
		Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
		Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
		Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
		Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
		Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
		Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>				
		Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>					
		Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>					
		Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
		Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					

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Page 2

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Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

400 4 11/24/2014

150

HandFinish

Memo

0.00

Hand Finishing

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

400 4 11/24/2014 DAS 38 9-69

160

Powdercoat

Memo

0.00

Powder Coating

(Flat End Only)

START TIME: 10:05

OVEN TEMPERATURE: 320

FINISH TIME: 10:35

170

QC3- Inspect Part Finish

0.00

400 DAS 38 9-69 NOV 24 2014

170

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>				Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>		Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence						<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

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Page 3

Item ID: D3492-1

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NS1

Revision ID:

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NS2

Item Name: Plug

Start Date: 10/27/14 Start Qty: 400.00

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Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: F12-001

0.00

180

Packaging

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.00

x400 d 20 10/20

14/12/2014

4-11-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General					
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Pressure/Forced
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>	Set-up
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>	Temperature/Cure
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>	Weld
						<input type="checkbox"/>	Wrong Stock Pulled
						<input type="checkbox"/>	Other

Picklist Print

Page 1

Friday, October 24, 2014 11:12:19 AM

Work Order ID: 125904

125904
D3492-1

Parent Item: D3492-1

Parent Item Name: Plug

Start Date: 10/27/14

Required Date: 11/28/14

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased		No		100	f	29.3545	0.0625	27			DAS 37 9-89 14-10-28

M6061T6R0 625

6061-T6 Round Bar .625"

Location	Loc Oty	Loc Code
MAT012	29.354474	
m126726	1.854474	
m1282654	3.5	
m129530	24	

3 ft.
24 ft

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear		General									
		Bending <input type="checkbox"/>	Bend <input type="checkbox"/>		Folio/Program <input type="checkbox"/>			Outside Dimensions <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>	
		Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>		Grain <input type="checkbox"/>			Over/Under tolerance <input type="checkbox"/>		Set-up <input type="checkbox"/>	
		Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>		Hardware <input type="checkbox"/>			Part Incorrect <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>	
		Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>		Inspection Incomplete/Unqualified <input type="checkbox"/>			Part Lost/Missing <input type="checkbox"/>		Weld <input type="checkbox"/>	
		Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>			Part Moved <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>	
		Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>		Misaligned/off center <input type="checkbox"/>			Positioned Wrong <input type="checkbox"/>			
		Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>		Mislabeled <input type="checkbox"/>			Power Loss/Surge <input type="checkbox"/>			
		Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>		Misread <input type="checkbox"/>						
		Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>		Off-set <input type="checkbox"/>						
		Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>						
		Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>						

DART AEROSPACE LTD	Work Order:	125904
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

DAS

Measured by:	37 9-89	Audited by:	JFC	Preliminary Approval:	
Date:	14.10.28	Date:	2014-11-06	Date:	

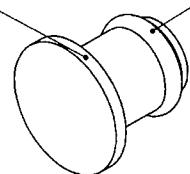
Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD	
E	11.07.26	Dimensions updated per Dwg Rev D	KJ	<i>CH</i>
F	14.01.21	Dwg Rev updated	KJ	<i>AM</i>



8 7 6 5 4 3 2 1

D D C C B B A A

D3492-XX PLUG (SEE TABLE) NAS1611 O-RING (SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X					D3492-041			PLUG ASSEMBLY	
	X				D3492-043			PLUG ASSEMBLY	
		X			D3492-045			PLUG ASSEMBLY	
			X		D3492-047			PLUG ASSEMBLY	
				X	D3492-049			PLUG ASSEMBLY	
					D3492-051			PLUG ASSEMBLY	
					X	D3492-053		PLUG ASSEMBLY	
						X	D3492-055	PLUG ASSEMBLY	
1					D3492-1			PLUG	
	1				D3492-3			PLUG	
		1			D3492-5			PLUG	
			1		D3492-7			PLUG	
				1	D3492-9			PLUG	
					D3492-11			PLUG	
					D3492-13			PLUG	
					1	D3492-15		PLUG	
							E		
					NAS1611-005			O-RING	
				1	NAS1611-007			O-RING	
1					NAS1611-010			O-RING	
					1	NAS1611-012		O-RING	
				1	NAS1611-013			O-RING	
						1	NAS1611-015	O-RING	
						1	NAS1611-016	O-RING	

NOTES:

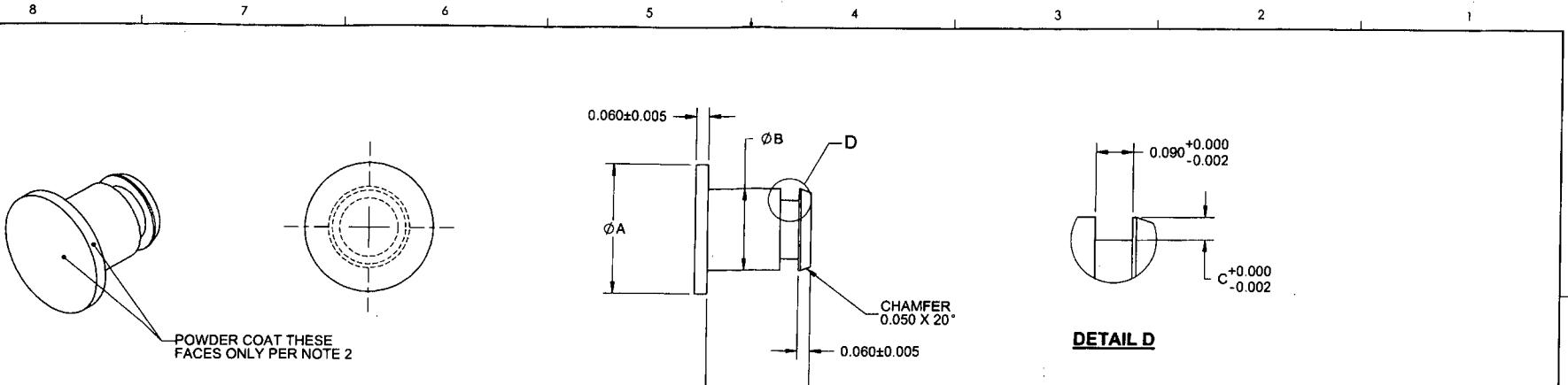
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

14-10-24
125904

RELEASED
2013-11-13
A

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DED D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CART-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	NA	D3492	SHEET 1 OF 2
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	PLUG	NTS
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

E

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DA	D3492	SHEET 2 OF 2
APPROVED	MO	TITLE	SCALE
DE APPR.	MM	PLUG	4:1
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD. *#	
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RELEASED
2013-11-13

